



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
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D412-709-011
Job Sheet 187777



007641

Part No: D412-709-011

Job Qty: 4 pcs

Part Name: Escape Panel Push-out Window Full, Clear - Fits LH or RH



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 12/17/18

Job Tracking No:

Due Date: 1/31/19

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG REV C IPP Rev:B Removed Manufacturing 05-11-06 JLM IPP rev C removed sub-components 07.11.12
EC IPP Rev:D 10.05.20 added D3561-1 DD ver:EC

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier	Sign-off
					Setup Hrs	Run Hrs		
100 135	DC - 1	4 pcs	1/31/19	1/31/19	0.00	0.00	DC - 1	
							DC - 2	
110	Packaging 1-1 - Pick Kit - B4B	4 pcs	1/31/19	1/31/19	0.00	0.00	Packaging 1 - 1 - B4B	
							Packaging 1 - 2 - B4B	
							Packaging 1 - 3 - B4B	
							Packaging 1 - 4 - B4B	
							Packaging 1 - 5 - B4B	
							Packaging 1 - 6 - B4B	
							Packaging 1 - 7 - B4B	
							Packaging 1 - 8 - B4B	
							Packaging 1 - 9 - B4B	
							Packaging 1 - 10 - B4B	
							Packaging 1 - 11 - B4B	
							Packaging 1 - 12 - B4B	
							Packaging 1 - 13 - B4B	
							Packaging 1 - 14 - B4B	
							Packaging 1 - 15 - B4B	
							Packaging 1 - 16 - B4B	
							Packaging 1 - 17 - B4B	
							Packaging 1 - 18 - B4B	
							Packaging 1 - 19 - B4B	
							Packaging 1 - 20 - B4B	
							Packaging 1 - 21 - B4B	
							Packaging 1 - 22 - B4B	
							Packaging 1 - 23 - B4B	
							Packaging 1 - 24 - B4B	
							Packaging 1 - 25 - B4B	
							Packaging 1 - 26 - B4B	
							Packaging 1 - 27 - B4B	
							Packaging 1 - 28 - B4B	
							Packaging 1 - 29 - B4B	
							Packaging 1 - 30 - B4B	

JAN 22 2019

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS <table style="width: 100%;"> <tr> <td>Skid-tube ☐</td> <td>Cross tube ☐</td> <td>Eng. (Non-AW) ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Water Jet ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Supplier Quality ☐</td> </tr> </table>				Skid-tube ☐	Cross tube ☐	Eng. (Non-AW) ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Water Jet ☐	Large Fab ☐	Finishing ☐	Rec/Store/Packaging ☐	Supplier Quality ☐	
Skid-tube ☐	Cross tube ☐	Eng. (Non-AW) ☐	Engineering ☐															
Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Water Jet ☐															
Large Fab ☐	Finishing ☐	Rec/Store/Packaging ☐	Supplier Quality ☐															
Date : _____	Sequence #: _____	QTY Affected : _____		MRB (QSI042) _____														
DART Aerospace Ltd. 1270 Aberdeen Street Hawkesbury, ON K6A 1K7 CANADA TEL : 1 613 632-5200 Email: sales@dartaero.com www.dartaerospace.com DART AEROSPACE Container No: S150645 Part: D412-709-011 Job No: 187777 Serial No/Batch: S150645 Revision: _____ Inspector: _____ Exp Date: _____ Instructions: TC STC SH04-31 Issue Date: 11/11/11			Disposition _____ _____ _____															
			Completed By _____															
			Lead hand / Supervisor _____															
			QC / QA Coordinator _____															
Handling Product Improvement ☐ Process Improvement ☐ Human Factors ☐		DRY <table style="width: 100%;"> <tr> <td>☐ Power Loss/Surge</td> <td>☐ Positioned Wrong</td> </tr> <tr> <td>☐ Folio/Program</td> <td>☐ Outside Tolerance</td> </tr> <tr> <td>☐ Grain Direction</td> <td>☐ Drawing</td> </tr> <tr> <td>☐ Weld</td> <td>☐ Finish</td> </tr> <tr> <td>☐ Wrong Stock Pulled</td> <td>☐ Part Lost/Missing</td> </tr> <tr> <td>☐ Out of Sequence</td> <td>☐ Misread</td> </tr> <tr> <td>☐ Off-set/Set-up</td> <td></td> </tr> </table>			☐ Power Loss/Surge	☐ Positioned Wrong	☐ Folio/Program	☐ Outside Tolerance	☐ Grain Direction	☐ Drawing	☐ Weld	☐ Finish	☐ Wrong Stock Pulled	☐ Part Lost/Missing	☐ Out of Sequence	☐ Misread	☐ Off-set/Set-up	
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Other/Details: _____ _____ _____		Remarks/Chatter _____ Mislabeled ☐ Drill Holes _____ Fit/Function _____																

					Packaging 1 - 31 - B4B	
					Packaging 1 - 32 - B4B	
					Packaging 1 - 33 - B4B	
					Packaging 1 - 34 - B4B	
					Packaging 1 - 35 - B4B	
120	QC 4	4 pcs	1/31/19	0.00 0.00	QC 4 - 26	
					QC 4 - 28	
					QC 4 - 38	
					QC 4 - 42	
					QC 4 - 58	
					QC 4 - 6	
					QC 4 - 69	
					QC 4 - 9	
					QC 4 - 46	
130	Packaging 3-1 - Stock - B4B	4 pcs	1/31/19	0.00 0.00	Packaging 3 - 1 - B4B	
					Packaging 3 - 2 - B4B	
					Packaging 3 - 3 - B4B	
					Packaging 3 - 4 - B4B	
					Packaging 3 - 5 - B4B	
					Packaging 3 - 6 - B4B	
					Packaging 3 - 7 - B4B	
					Packaging 3 - 8 - B4B	
					Packaging 3 - 9 - B4B	
					Packaging 3 - 10 - B4B	
					Packaging 3 - 11 - B4B	
					Packaging 3 - 12 - B4B	
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					Packaging 3 - 28 - B4B	
					Packaging 3 - 29 - B4B	
					Packaging 3 - 30 - B4B	
					Packaging 3 - 31 - B4B	
					Packaging 3 - 32 - B4B	
					Packaging 3 - 33 - B4B	
					Packaging 3 - 34 - B4B	
					Packaging 3 - 35 - B4B	
140	QC 21 - FG	4 pcs	1/31/19	0.00 0.00	QC 21 - FG - 21	
					QC 21 - FG - 70	

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

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Date : _____	Sequence #: _____	QTY Affected : _____		MRB (QSI042) _____	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor	
				QC / QA Coordinator	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details: _____					

AN6-20A	Bolt	12 Ea (3 ea)	100-DC - 1	5064084
D3118-3	Sign Assembly	4 pcs (1 ea)	100-DC - 1	508123603 5121808 X1
D3224-1	Frame	4 pcs (1 ea)	100-DC - 1	5146519
D3239-1	Cover	8 pcs (2 ea)	100-DC - 1	51591624 5059066 X1
D412-709-013	Escape Panel Push-out Replacement Window, Clear - Fits LH or RH	4 pcs (1 ea)	100-DC - 1	5149403
MS21042L3	Nut	8 Ea (2 ea)	100-DC - 1	502361
MS21042L6	Nut	12 Ea (3 ea)	100-DC - 1	507156
MS35207-262	Screw	8 Ea (2 ea)	100-DC - 1	5027735
NAS1149D0332J	Washer	8 Ea (2 ea)	100-DC - 1	5013757
NAS1149D0616J	Washer	20 Ea (5 ea)	100-DC - 1	5027737
NAS1149D0663J	Washer	20 Ea (5 ea)	100-DC - 1	5093765

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-DC - 1	AN6-20A	12	18	0
	D3118-3	4	5	0
	D3224-1	4	0	0
	D3239-1	8	11	0
	D412-709-013	4	1	0
	MS21042L3	8	2,887	0
	MS21042L6	12	260	0
	MS35207-262	8	85	0
	NAS1149D0332J	8	1,390	0
	NAS1149D0616J	20	276	0
	NAS1149D0663J	20	1,312	0

Part Specifications

Specifications could not be found.

Entered: _____ Date: _____



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Description Work Order Deviation		Disposition		Completed By	
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Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐ ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					

5.0 PARTS LIST

Qty -011	Qty -013	Qty -015	Qty -017	Qty -019	Qty -021	Qty -023	Part Number	Description
X							D412-709-011	ESCAPE PANEL MODIFICATION KIT
1	X						D412-709-013	ESCAPE PANEL PUSH OUT WINDOW KIT
		X					D412-709-015	HINGE PANEL DOOR MODIFICATION KIT
		1	X				D412-709-017	HINGE PANEL DOOR REPLACEMENT WINDOW KIT
				X			D412-709-019	CARGO DOOR PUSH OUT WINDOW KIT
					X		D412-709-021	HINGE PANEL DOOR PUSH OUT WINDOW MODIFICATION KIT
					1	X	D412-709-023	HINGE PANEL DOOR REPLACEMENT PUSH OUT WINDOW KIT
			1				D2126-0720	LOCKING SEAL
1							D3118-3	SIGN ASSEMBLY
				1			D3136-041	WINDOW ASSEMBLY
	1						D3136-043	WINDOW ASSEMBLY
1							D3224-1	FRAME
			1				D3236-1	WINDOW
						1	D3237-1-0720	SEAL RETAINER
	1			1			D3237-1-0980	SEAL RETAINER
						1	D3237-3-0720	SEAL FILLER
	1			1			D3237-3-0980	SEAL FILLER
2							D3239-1	COVER
		1					D3240-1	FRAME
						1	D3543-1	HINGE PANEL DOOR PUSH OUT WINDOW
					1		D3543-3	HINGE PANEL DOOR PUSH OUT WINDOW FRAME
	1			1		1	D3561-1	WINDOW SEAL TOOL
3							AN6-20A	BOLT
2							AN960JD10L	WASHER
5							AN960JD616	WASHER
5							AN960JD616L	WASHER
2							MS21042L3	NUT
3							MS21042L6	NUT
2							MS35207-262	SCREW

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Revision: C

Date: 06.11.27